



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3205-1
Job Sheet 193503



Part No: D3205-1

Job Qty: 8 pcs

Part Name: Pedal Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/16/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 4/26/19

Type: SOLD

Description:

Note: DWG REV C IPP A 04.06.09 New issue KJ/RF IPP Rev:B 08-12-16 attach DEO DD verified by:EC IPP REV:C AS PER REV B 12-03-23 JLM VERIFIED BY:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	8 pcs		4/26/19	0.00	0.92	Bandsaw - 1		DJP 19-04-22
110	HAAS 4 Axis - B4B	8 pcs		4/26/19	0.58	32.00	HAAS - 1 - B4B		DJP 19-04-22
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	8 pcs		4/26/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		DJP 19-04-22
							QC 2 - 57		
							QC 2 - 62		



Container No: S173761



Part: D3205-1

Job No: 193503

Serial No/Batch: S173761

Revision:

Inspector:

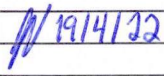
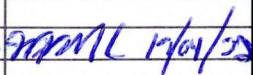
Exp Date:

Instructions: Various STC's

Date: 04/22/19

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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
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Plex 4/16/19 9:15 AM Dart.lajeunesse.marie

						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
121	Conventional Mill - 1 - B4B	8 pcs	4/26/19	0.00	8.00	Conventional Mill - 1 - B4B	
						Conventional Mill - 2 - B4B	
122	QC 2	8 pcs	4/26/19	0.00	0.00	QC 2 - 1	
						QC 2 - 12	
						QC 2 - 14	
						QC 2 - 17	
						QC 2 - 19	
						QC 2 - 2	
						QC 2 - 20	
						QC 2 - 22	
						QC 2 - 23	
						QC 2 - 25	
						QC 2 - 32	
						QC 2 - 33	
						QC 2 - 35	
						QC 2 - 39	
						QC 2 - 4	
						QC 2 - 40	
						QC 2 - 44	
						QC 2 - 45	
						QC 2 - 48	
						QC 2 - 49	
						QC 2 - 50	
						QC 2 - 51	
						QC 2 - 52	
						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
130	QC 8	8 pcs	4/26/19	0.00	0.00	QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	

					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
140	Handfinish - 1-1 Chemical-B4B	8 pcs	4/26/19	0.00 0.67	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R. 19/04/23
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Powdercoat - 3 Grey Sand - B4B	8 pcs	4/26/19	0.00 0.67	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160	QC 3	8 pcs	4/26/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	

27.3/8

170 Packaging 3-1 - Stock - B4B	8 pcs	4/26/19	0.00	0.00	QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	DAS
					QC 3 - 40	40
					QC 3 - 19	9-89
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	GA118
					Packaging 3 - 28 - B4B	APR 23 2019
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	

180 QC 21 - SA	8 pcs	4/26/19	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89

Part Op 100 - (Bandsaw) Cut blanks: 3.250" x 2.500" x 4.250" long Bar (+0.030/-0.000)
 Descriptions: 110 - (HAAS CNC Vertical Machine) Machine D3205-1 as per Folio FA346 and Dwg D3205 Identify as D3205-1
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 121 - (Manufacture as per dwg) COUNTER SINK AS PER DWG
 122 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) Note: Cover the thread hole for D3205-1 before powder coat.
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____) LOCATION : GA
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B2.500X03.25	7075-T73 Bar 2.50 X 3.25	2.9168 ft (.3646 ea)	100-Bandsaw - 1	5076664

$3646 \times 6 \Rightarrow 2.1876$

$2.280 - 2.1876 \Rightarrow 0.0924 \text{ scrap}$

MAT
used
2.280

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T73B2.500X03.25	3	2	0
Part Specifications				
Specifications could not be found.				

Gave Chantel
to order

a.marie

DART AEROSPACE LTD		Work Order:	
Description: Pedal Bracket		Part Number:	D3205-1
Inspection Dwg: D3205 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.097	✓		Vern.	
0.250	+/-0.010	0.253	✓		Vern.	
R0.38	+/-0.030	0.375	✓		Vern. Rad. Gage	
0.125	+/-0.010	0.131	✓		Vern.	
0.250	+/-0.010	0.253	✓		Vern.	
2.380	+/-0.010	2.376	✓		Vern.	
1.380	+/-0.010	1.381	✓		Vern.	
0.500	+/-0.010	0.501	✓		Vern.	
0.880	+/-0.010	0.881	✓		Vern.	
Ø0.470 x 100°	+0.006/-0.001	0.475	✓		Vernier JVO5	Conv. Mill.
0.440	+/-0.010	0.440	✓		Vern.	
0.600	+/-0.010	0.600	✓		Vern.	
1/4-28UNF-313	N/A	1/4-28 UNF	✓		Go/NoGo	
* 0.250	+/-0.010	0.243	✓		Vern.	
Ø0.257	+0.006/-0.001	0.2575	✓		G.P.	
1.750	+/-0.010	1.752	✓		Vern.	
0.870	+/-0.010	0.870	✓		Vern.	
0.440	+/-0.010	0.440	✓		Vern.	
R0.25	+/-0.030	0.250	✓		R. Gage	
3.000	+/-0.010	3.001	✓		Vern.	
3.96	+/-0.030	3.965	✓		H.G.	
0.409	+/-0.010	0.410	✓		H.G.	
0.808	+/-0.010	0.809	✓		H.G.	
2.562	+/-0.010	2.564	✓		Vern.	

Measured by: DJP	Audited by: VJH/aml	Preliminary Approval:
Date: 19-04-21	Date: 19/4/21 / 19/4/21	Date:

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	12.05.14	Dimensions updated per Dwg Rev B	KJ	
C	13.02.27	Dwg Rev updated	KJ	

Entered:

Date: 19-04-22



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: <u>193503</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☒ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐					
Date : <u>19-04-22</u>	Sequence #: <u>110</u>		QTY Affected : <u>1</u>			MRB (QSI042) DAS 9 19-04-22 9-89			
Description Work Order Deviation <u>Part Origine (G55) was off on "X" Axis</u>			Disposition <u>SCRAP</u>			Completed By <u>DJP</u> <u>19-04-22</u>			
						Lead hand / Supervisor <u>B</u> <u>19-04-22</u>			
						QC / QA Coordinator DAS 68 9-89 <u>APR 27 2019</u>			
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐			FAULT CATEGORY Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Misaligned/off center ☒ Folio/Program ☐ Outside Tolerance ☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Drawing ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Finish ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Misread ☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up ☐						
			Other/Details:						